

Ship July 6

Dart Aerospace Ltd.

Date: Tuesday, 6/26/2007 3:06:32 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 33130		
Estimate Number	: 12626		
P.O. Number	:	Part Number	: D2127251105
This Issue	: 6/26/2007 S.O. No. :	Drawing Number	: D212-725-1 REV A <i>JB</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: <i>KB</i>
Previous Run	: 30167	Material	: <i>N/A</i>
Written By	:	Due Date	: 7/3/2007
Checked & Approved By	: <i>JA 07.06.27</i>	Qty:	<i>10</i> Um: Each
Comment	: Est Rev.A New Issue 07-01-04 JLM		<i>61</i>

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304R1500



Comment: Qty.: 0.0368 f(s)/Unit Total : 0.3675 f(s)

304SS 1.500" ROUND BAR

Batch: *103156**JA / RP 07/07/00*

2.0 HARDINGE



HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA660& DWG D212-725-1,

FOLIO REV: *A*DWG REV: *B*

2-DEBURR AS REQUIRED

JA / RP 07/07/00

3.0 QC2



INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JA / RP 07/07/00 (64)

4.0 QC8



SECOND CHECK



Comment: SECOND CHECK

JA 07.07.24

5.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/7/24 SQ (64x)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/26/2007 3:06:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 33130

Part Number: D2127251105

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



64

Comment: FINAL INSPECTION/W/O RELEASE

20767/26

Job Completion



W/O 07-25

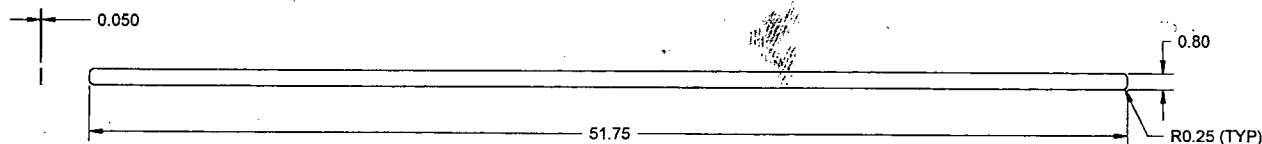
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

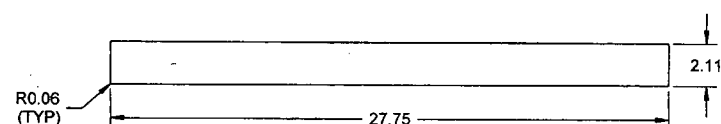
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

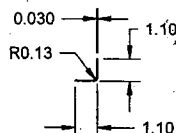
NOTE: Date & initial all entries



D212-725-1-089 STRAP



D212-725-1-091F FLAT PATTERN



D212-725-1-091 ANGLE
(MAKE FROM D212-725-1-091F FLAT PATTERN)

D212-725-1-089 NOTES:

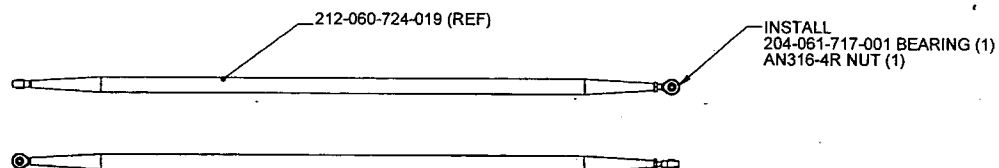
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.050 (18 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S18GA)

D212-725-1-091 NOTES:

2) MATERIAL: AISI 304/316 STAINLESS STEEL 0.030 (22 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S22GA)

GENERAL NOTES:

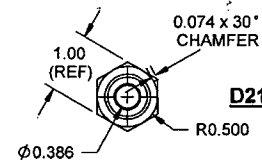
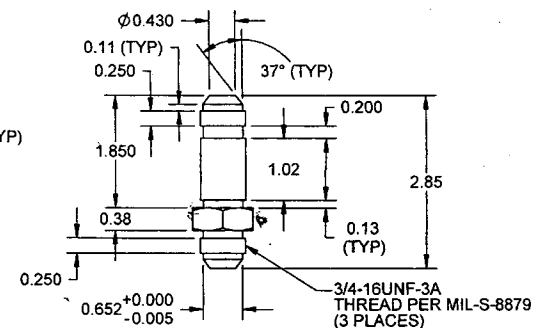
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



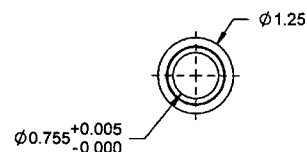
D212-725-1-919 ROD ASSEMBLY
(MADE FROM 212-060-724-019)

D212-725-1-919 NOTES:

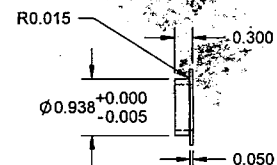
- 1) MATERIAL: MADE FROM 212-060-724-019 TUBE ASSEMBLY
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



D212-725-1-093 UNION
(SCALE 1:3)



D212-725-1-105 BUSHING
(SCALE 1:3)



D212-725-1-105 BUSHING:

1) MATERIAL: AISI 303/304/316 STAINLESS STEEL ROUND BAR (REF. DART SPEC. M303R)

D212-725-1-093 UNION:

2) MATERIAL: AISI 303 STAINLESS STEEL HEX BAR (REF. DART SPEC. M303H)

GENERAL NOTES:

- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

B	07.05.11	D212-725-1-919 WAS D212-725-1-921	
A	06.12.08	NEW ISSUE	
DESIGN	DC	DRAWN BY	RF
CHECKED	DS	APPROVED	
DATE	07.05.11	DRAWING NO.	D212-725-1
		TITLE	212S DETAIL PARTS
		REV. B	SHEET 33 OF 44
		SCALE	1:6

COPYRIGHT © 2006 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

NO. 23130
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

DART AEROSPACE LTD		Work Order:
Description: Crosstube Assembly <i>Bushings</i>		Part Number: <i>DDA-725-1-105</i>
Inspection Dwg:	Rev: <i>B</i>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	<i>1.250 Ø</i>	<i>+0</i>	<i>1.249</i>				
	<i>.938 Ø</i>	<i>-.005+0</i>	<i>.937</i>				
	<i>.755 Ø</i>	<i>+0.005-0</i>	<i>.758</i>				
	<i>.300</i>	<i>+-.010</i>	<i>.297</i>				
	<i>.050</i>	<i>+-.010</i>	<i>.054</i>				
	<i>R.015</i>	<i>+-.010</i>	<i>R.015</i>				
SIDE B							

Measured by: <i>RP</i>	Audited by: <i>J.F.</i>	Prototype Approval:	<i>N/A</i>
Date: <i>07/07/16</i>	Date: <i>07/07/16</i>	Date:	<i>N/A</i>
Rev	Date	Change	Revised by Approved
<i>A</i>		<i>New Issue</i>	<i>KJ/JLM</i>